

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011413**Date Inspected:** 09-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD (Lift 5 East)**

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 5 East for smoothness and appeared to comply with the ABF inspection report no: CWAHIR-5E-03 dated 30th Dec 2009

This QA Inspector randomly observed the following work in progress:

**OBG # TRIAL ASSEMBLY YARD (6BW-6CW)****SMAW Process:**

Welding of weld joint – 023 and 024 located on PCMK DP624-001, Deck Panel “I” Stiffener Counter Weight Side.

Welder is identified as 066481. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3b.

**OBG # TRIAL ASSEMBLY YARD (6AW-6BW)**

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## WELDING INSPECTION REPORT

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### SMAW Process:

Welding of weld joint – 006 located on PCMK SEG029B, Longitudinal Diaphragm Counter Weight Side. Welder is identified as 068764. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

### FCAW Process:

Welding of weld joint – 007 located on PCMK SEG029A, Longitudinal weld joining Side Panel to Bottom Panel Cross Beam side. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-2.

OBG # TRIAL ASSEMBLY YARD (6AE-6BE)

This QA Inspector observed ZPMC personnel performing Heat Straightening for the Longitudinal Diaphragm for Segment 6AE to 6BE between PP 40 and PP41 at Bike Path side. Heat straightening been performed as they were misaligned. Heat Straightening been performed against the Heat Straightening Report (HSR) HSR1 (B)-7928 Rev. 0 Dated Nov 23, 2009.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Manikandan,Murugan | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Miller,Mark        | QA Reviewer                 |

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